

Work Order ID 56901



Page 1

March 12, 2010 12:57:13 PM

Item ID: D3781-041

Accept



Setup

Start



Revision ID:

Item Name: Lateral Cushion Assembly

Stop



Start Date: 12/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

H

Date: 10-3-12

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3781	Rev D
-------	-------

100



Purchasing

Purchasing

Memo

0.00

*C2 10/3/15 6*Issue P/O: 11507

Ship with D3781-1 SUPPORTING PLATE

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER
 D3781-1/3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY
 FABRIC P/N SY-11. BOND FABRIC USING 3M 1300/1300L ADHESIVE
 (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S
 INSTRUCTIONS

THREAD: MIL-VT-295 TYPE2 CLASS A, GREY NYLON THREAD, 4-6
 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS.

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

P10/3/15 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56901

March 12, 2010 12:57:13 PM



Page 2

Item ID: D3781-041

Revision ID:

Item Name: Lateral Cushion Assembly

Start Date: 12/03/2010 Start Qty: 6.00

Required Date: 26/03/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

8/10/10

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 185

0.00

Memo

10/04/10

Pto →

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

10/04/12

u 10-04-08

WO: 56901

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/4/01	# 121.A	Perm. Change (10.04.13) Locate and open/Renew Fabric around holes. -Clean all residue around holes	JP	10/4/01	6		S 10/4/01
10/4/01	# 121.B	Inspect QCS that holes are in correct location to Drawing	S	10/4/01	*6		10/4/01

Part No: D3781-04 | PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 12, 2010 12:57:18 PM

Page 1

Work Order ID: 56901



Parent Item: D3781-041



Parent Item Name: Lateral Cushion Assembly

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A 08-05-05 new issue DD verified by:EC
IPP Rev:B 08-07-22 revB as per dwg DD verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3781-1		Manufactured	No				Each	0.0000	6.0000			



Supporting Plate

X6 B 56934 12/03/24

D3781-041P

6 56901 12/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

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D

C

C

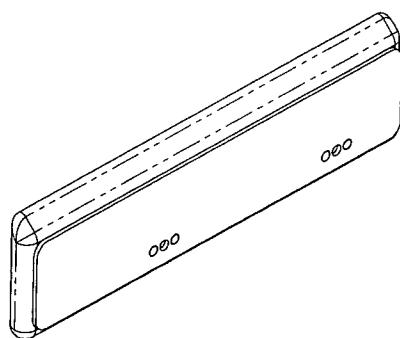
B

B

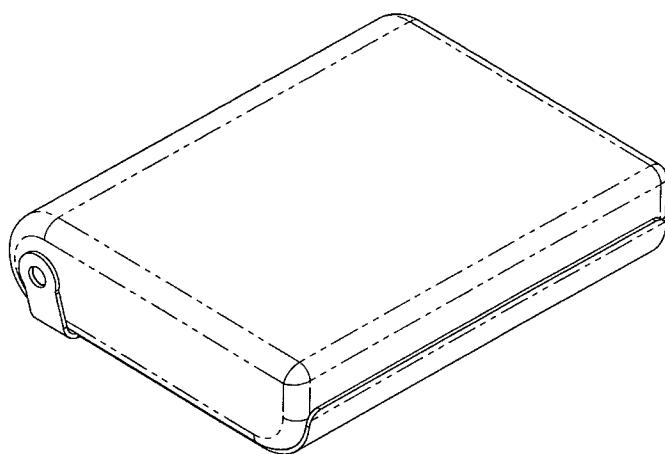
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A

D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



56901

RELEASED
(07/14/04)

D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION		
DESIGN	BY DATE		
DRAWN	DRAWN		
CHECKED	CHECKED		
MFG. APPR.	MFG. APPR.		
APPROVED	APPROVED		
DE APPR.	DE APPR.		
DATE	DATE 09.05.21		
DART AEROSPACE LTD		REV. D	
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 6	
DRAWING NO.		TITLE	
D3781		CUSHION ASSEMBLY	
SCALE		NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

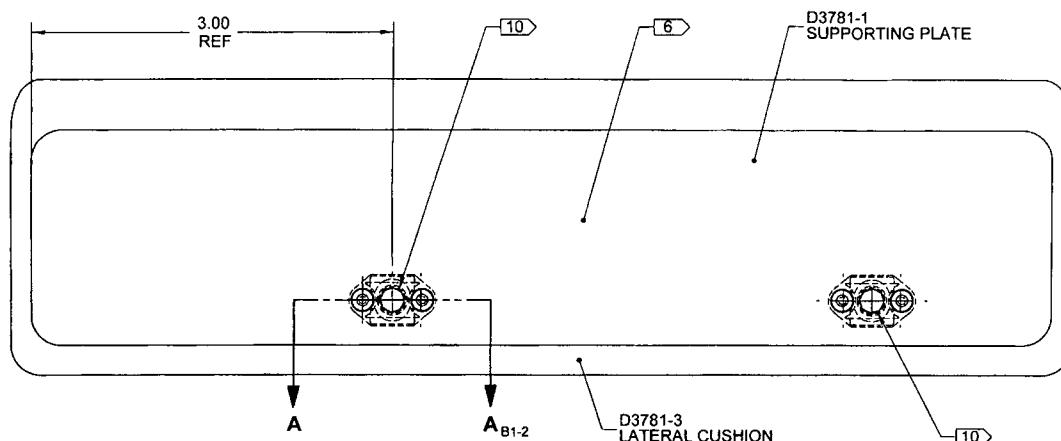
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

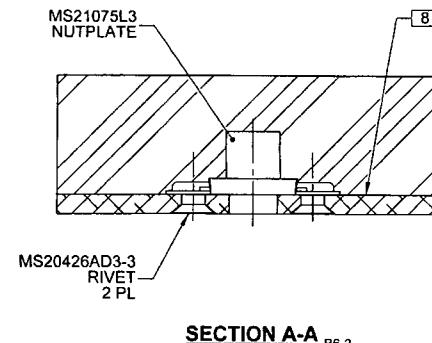
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



SECTION A-A B6-2
2 PL, SCALE 2X

D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS. POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

8 7 6 5 4 3 2 1

DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	1	D3781	SHEET 2 OF 6
APPROVED	AN	TITLE	SCALE
DE APPR.	2	CUSHION ASSEMBLY	NTS
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RELEASED
09/07/14

56901

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

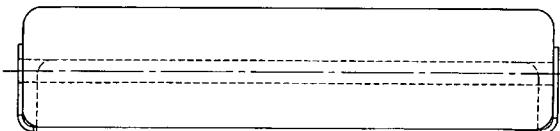
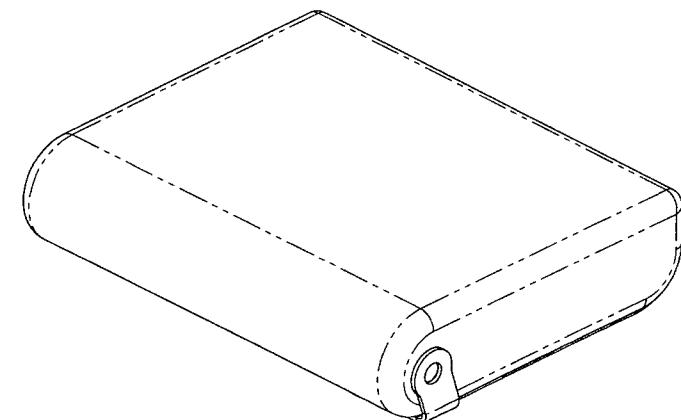
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

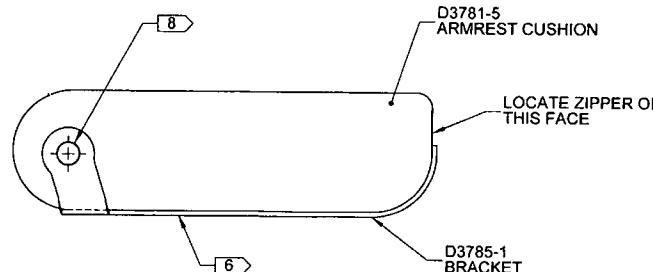
8 1 7 1 6 1 5 1 4 1 3 1 2 1 1



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

D3781-043 NOTES:

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
ZIPPER P/N: AI-Z021
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC



56901

RELEASED
(09/07/14 MP)

DESIGN	<i>1/2</i>	DART AEROSPACE LTD	
DRAWN	<i>1/2</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1/2</i>	DRAWING NO.	
MFG. APPR.	<i>1/2</i>	D3781	REV. D
APPROVED	<i>1/2</i>	SHEET 3 OF 6	
DE APPR.	<i>1/2</i>	TITLE	SCALE
DATE	09.05.21	CUSHION ASSEMBLY	NTS

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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

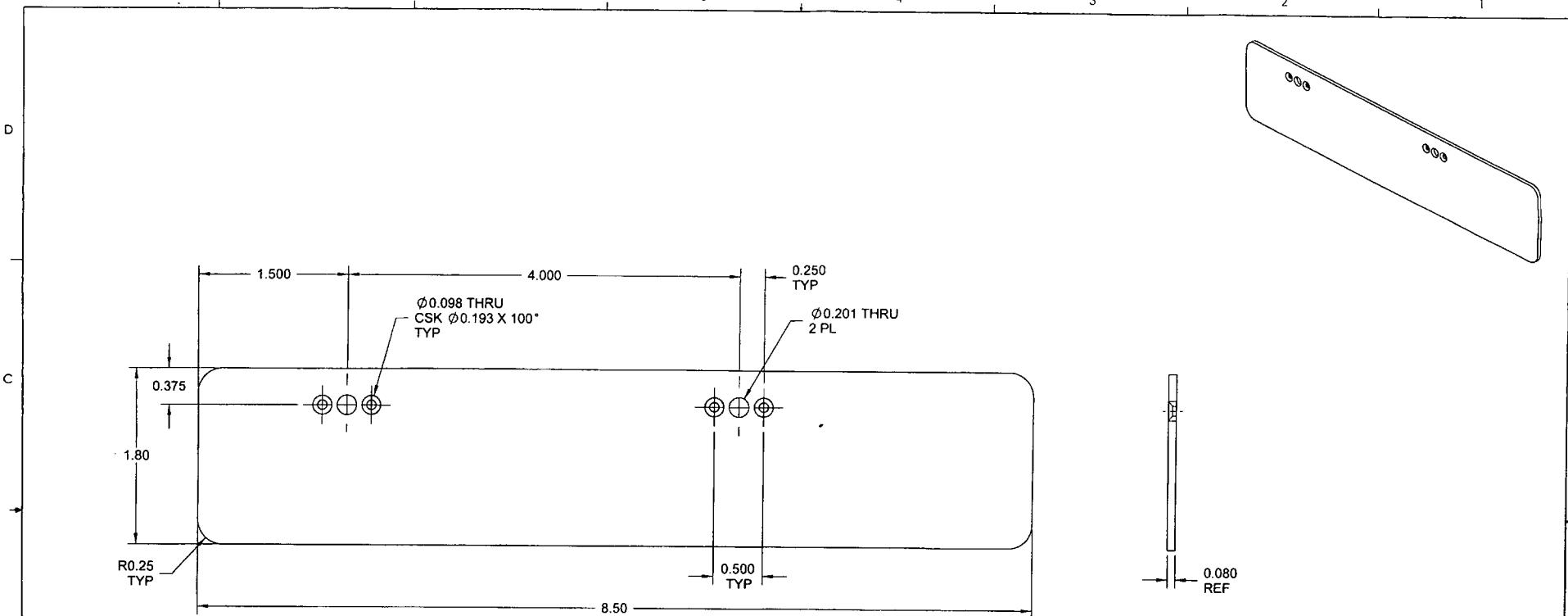
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

**D3781-1 SUPPORTING PLATE**

56901

RELEASED
(09/07/4 MTD)**D3781-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

8 7 6 5 4 3 2 1

DESIGN	12	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	AJS	REV. D
MFG. APPR.		D3781
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE
DATE	09.05.21	SCALE
		NTS
		CUSHION ASSEMBLY
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8 7 6 5 4 3 2 1

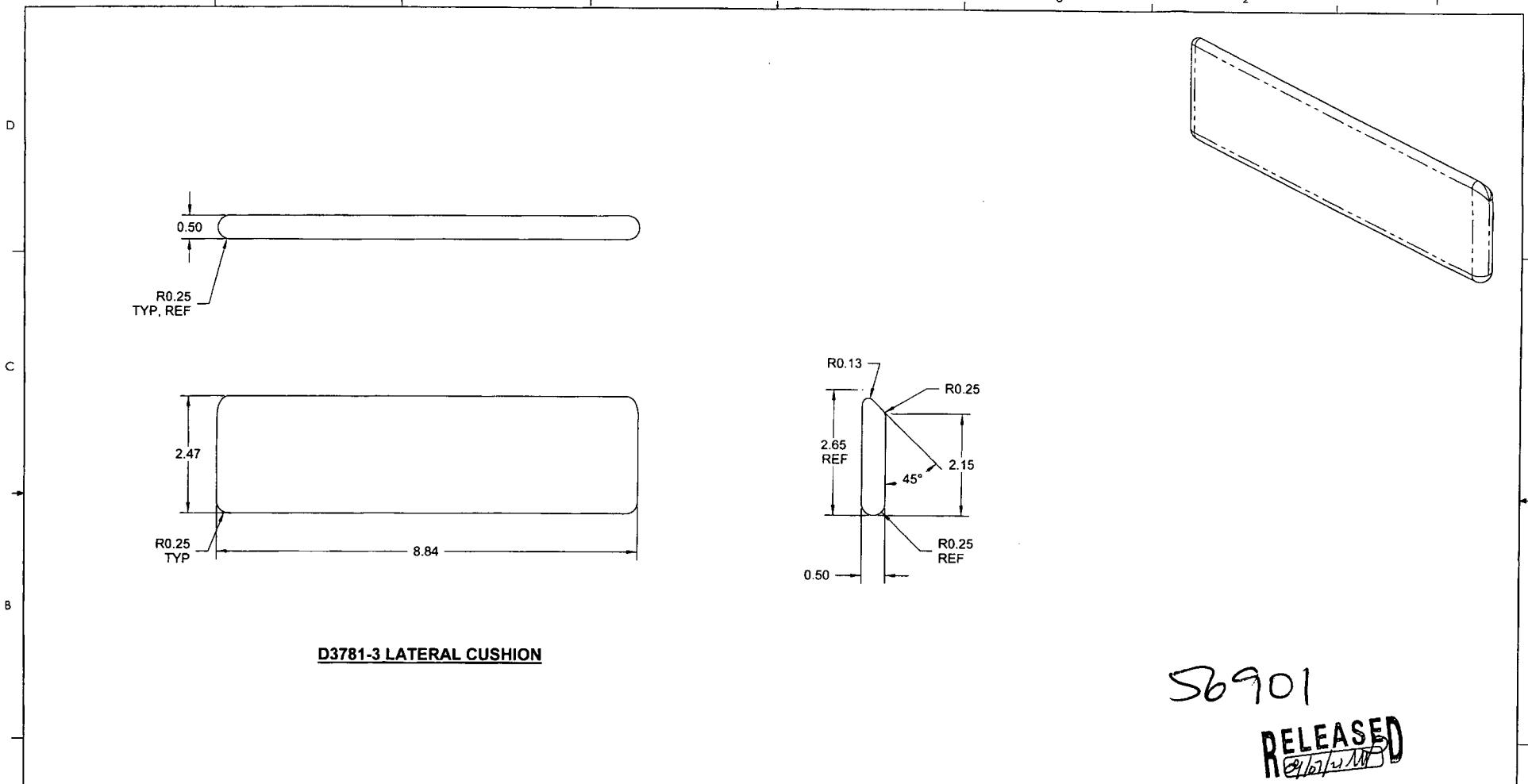
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1



D3781-3 LATERAL CUSHION

A **D3781-3 NOTES:**

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

DESIGN	<i>13</i>	DART AEROSPACE LTD
DRAWN	<i>13</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>13</i>	DRAWING NO. REV. D
MFG. APPR.	<i>13</i>	D3781 SHEET 5 OF 6
APPROVED	<i>13</i>	TITLE SCALE
DE APPR.	<i>13</i>	CUSHION ASSEMBLY NTS
DATE	09.05.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

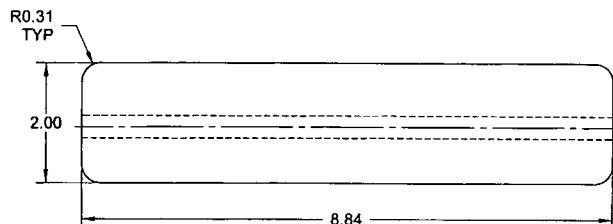
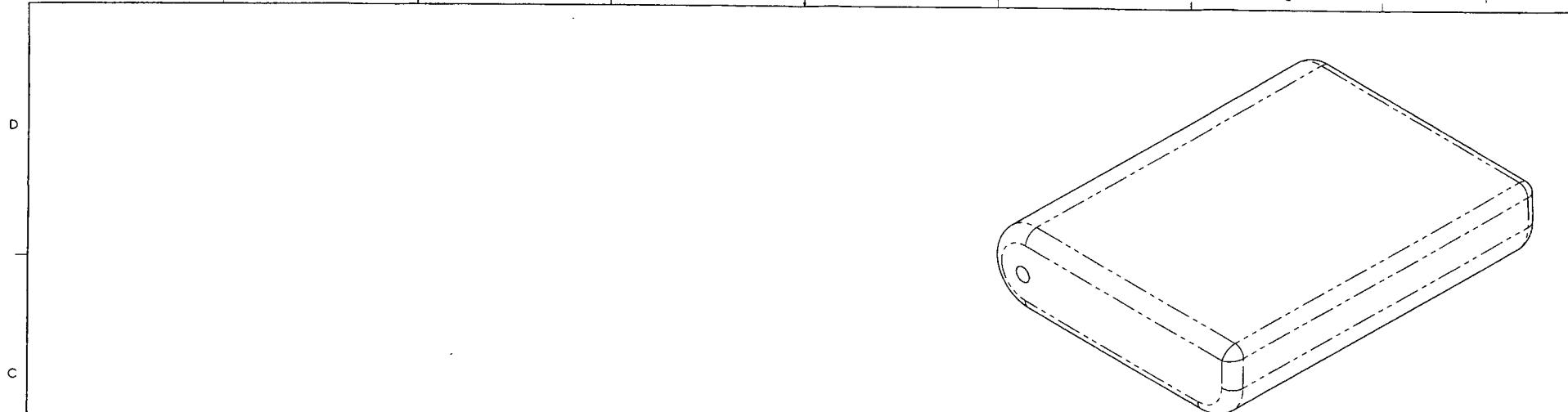
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

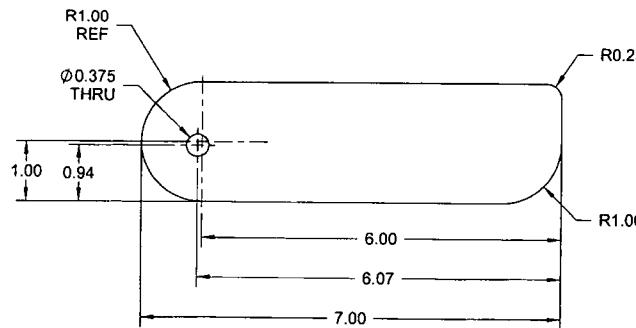
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3781-5 ARMREST CUSHION



56901

RELEASED
09/05/2011

D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. D
APPROVED	<i>[Signature]</i>	D3781
DE APPR.	<i>[Signature]</i>	SHEET 6 OF 6
DATE	09.05.21	TITLE
		SCALE
		NTS
		CUSHION ASSEMBLY
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1

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

pace Ltd.
rdeen Street
ury, ON K6A 1K7
3 632 9577

OUTSTANDING PO REPRINT

Purchase Order ID PO11507

Purchase Order Date 3/15/10

PO Print Date 3/24/10

Page Number 1 of 2

er From : VC-AER003

AEROTEX INTERIORS INC.
#24-2333 18TH AVENUE N. E.
CALGARY, AB T2E 8T6
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Line Nbr	Reference	Description/	Req Date/	Req Qty	Unit Price	Extended Price
	Revision ID	Mfg ID	Taxable			
	Vendor Part Number					
Ship To :	DART AEROSPACE LTD	1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA				

Line Nbr	Reference	Description/	Req Date/	Req. Qty/	Ship Method	Unit Price	Extended
	Revision ID	Mfg ID	Taxable	Unit of Measure			Price
	Vendor Part Number						
1	d3781-041P	Lateral cushion ass'y	3/23/10 Yes	6.00 Each	FedEx PI collect	\$175.0000	\$1,050.00

Special Inst: AS PER DWG D3781 REV. D
B56901

MATERIAL: SKANDIA HR150
POLYFOAM (4.6 LBS/CU FT)AND
COVERD37-1/-3 ASSEMBLY WITH
SILVER SUNSET UPHOLSTERY
FABRIC P/N: SY-11. BOND FABRIC
USING 3M 1300/1300L ADHESIVE
(0.002" TO 0.010" THICK) IN
ACCORDANCE WITH
MANUFACTURE INSTRUCTION
THREAD: MIL-VT-295 TYPE 2 CLASS
A, GREY NYLON THREAD, 4-6
STITCHES PER INCHS, USE MIN.
BACKSTITCH, NO LOOSE THREADS

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

AEROTEX
INTERIORS

#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date	Packing Slip#
30/03/2010	6221

Ship To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FedEx	15179324-0

Invoice To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship Date	P.O. No.
30/03/2010	11507

Description	ALT. Part Number	Part Number	Qty
LATERAL CUSHION ASSY. GST On Sales <i>S 10/04/10</i>		D3781-041P	6

Thank you for doing business with Aerotex Interiors.!

www.aerotexinteriors.com

GST/HST No.

139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295-8770 - Fax: (403) 313-0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:

Our Work Order:

81004101

PO11507

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THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

- FOAM - HR150
- THREAD - MIL-V-T-295, CLASS A, TYPE II
- VINYL - SURREY SILVER

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRIM WITH FAR 27.853(a), 29.853(a) and DWG. D3781 Rev D

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A handwritten signature in black ink, appearing to read "John Smith".